

# Work Order ID 52075

September 16, 2009 8:48:52 AM



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Item ID: D3278-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Support Assembly

73

Start Date: 9/16/09

Start Qty: 60.00



Cust Item ID:

Required Date: 9/22/09

Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet spacers with support as per Dwg D3278.

*EP 09/09/16* (73)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*2) Serial*

*cont*  
(73) *φ*

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble support as per Dwg D3278. \*\*\*DO NOT TIGHTEN BOLTS\*\*\* Identify as D3278-041

*EP 09/09/17* (73)

# Work Order ID 52075

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Item ID: D3278-041  
Revision ID: C  
Item Name: Support Assembly

Accept



Setup Start



Stop



Start Date: 9/16/09 Start Qty: 60.00



Cust Item ID:

Required Date: 9/22/09 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 8/20/09/17

count  
(73) /

140

Identify as per dwg & Stock Location: 471

0.00



Packaging

Memo

0.00

Packaging

9/19/21 (73Y) SP

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/21 [Signature]

CL 09/09/21

# Picklist Print

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Work Order ID: 52075

Parent Item: D3278-041RevC

Parent Item Name: Support Assembly


Comments:

Start Date: 9/16/09

Required Date: 9/22/09

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-13A		Purchased	No			120	Each	833.0000	120.0000			
												
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	833	
107321	1	
107534	5	
107959	23	
109285	37	
110552	66	
110865	3	
111477	13	
111925	7	
112314	678	
17406	0	
51764	0	

146  
9/16/09  
9/16/09/16

# Picklist Print

September 16, 2009 8:48:49 AM

Work Order ID: 52075

Parent Item: D3278-041RevC

Parent Item Name: Support Assembly

Comments:

Start Date: 9/16/09

Required Date: 9/22/09

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			120	Each	8,654.000	292 240.0000			



Washer

*EP 09/09/16*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	8654
102929	2
105906	4
106277	6
107321	23
107939	114
108161	553
108827	31
109249	69
110523	340
111279	101
111916	2404
112314	4887
16941	0
9222	120

D2230-1RevG

Manufactured No

120 Each 193.0000 146  
120.0000



Lug

*292*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FG	193
51427	193

*EP 09/09/16*

*146*

# Picklist Print

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Work Order ID: 52075

Parent Item: D3278-041RevC

Parent Item Name: Support Assembly



Comments:

Start Date: 9/16/09

Required Date: 9/22/09

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3278-1RevC		Manufactured	No			100	Each	146.0000	60.0000			
												
Support												

*Ep 09/09/16*

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	106
36811	2
43418	25
45401	2
47896	20
51353	57

            
            
            
            
19  
14

Main Warehouse

ST039	40
50472	40

40

D3278-2RevC

Manufactured No

100 Each 116.0000 60.0000



Support



*Ep 09/09/16*

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	116
47197	1
47897	21
50477	45
51354	49

            
21  
45  
49

# Picklist Print

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Work Order ID: 52075

Parent Item: D3278-041RevC

Parent Item Name: Support Assembly


Comments:

Start Date: 9/16/09

Required Date: 9/22/09

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3278-3RevC		Manufactured	No			100	Each	75.0000	60.0000			
												
Spacer												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST081

75

50323

2018

51188

55

MS20426AD3-6

Purchased

No

120

Each

2,952.000 240.0000



Rivet

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

2952

105055

2952

*EP 09/09/16*

*18*  
*255*

*292*  
*EP 09/09/16*

*292*

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Shop Packet Print

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## Picklist Print

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**Work Order ID:** 52075

**Parent Item:** D3278-041RevC



**Parent Item Name:** Support Assembly

**Comments:****Start Date:** 9/16/09

**Required Date:** 9/22/09

**Start Qty: 60.00**

**Required Qty: 60.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4  Nut		Purchased	No			100	Each	8,364.000	<sup>146</sup> <del>120.0000</del>		 EFB09/09/16	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

## Main Warehouse

ST	8364
105938	36
107499	5
108145	24
110450	1
110507	184
111827	5996
112314	1972
15924	0
7690	24
8182	41
9629	81

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## Shop Packet Print

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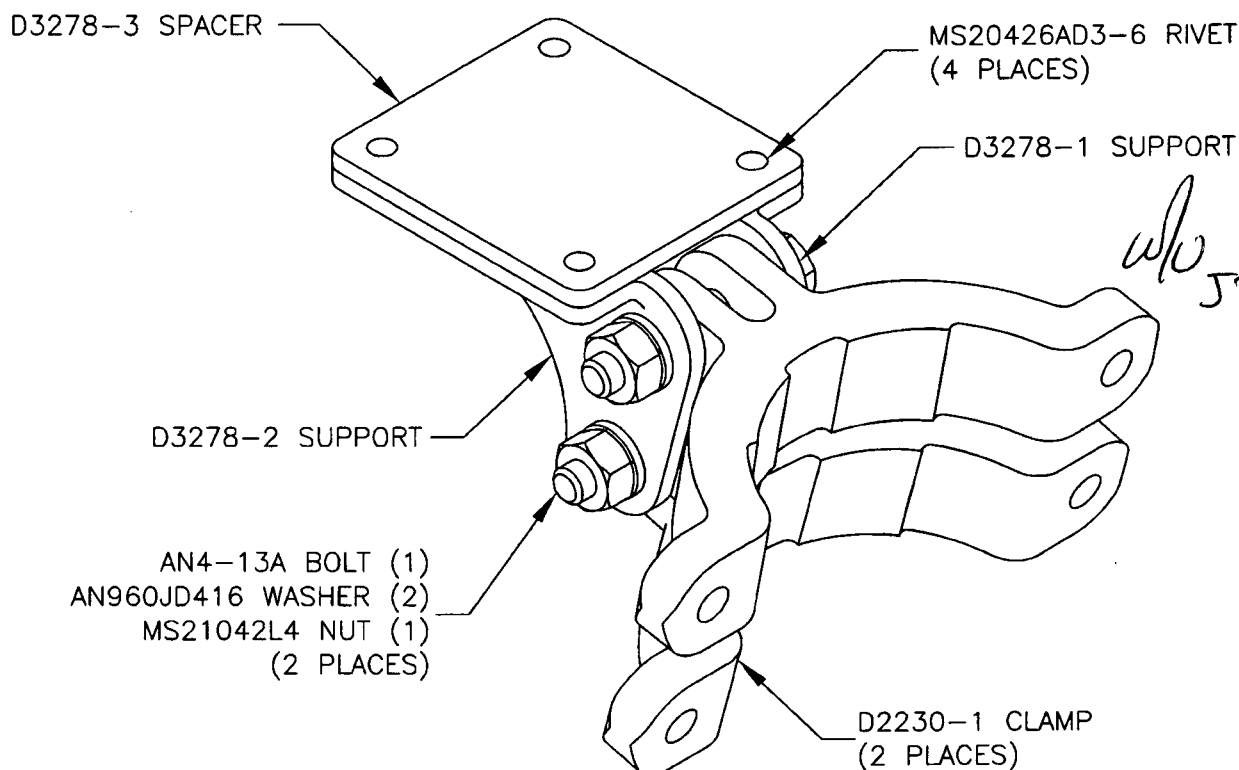
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**DART**

DESIGN 99	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
07-08-06

## D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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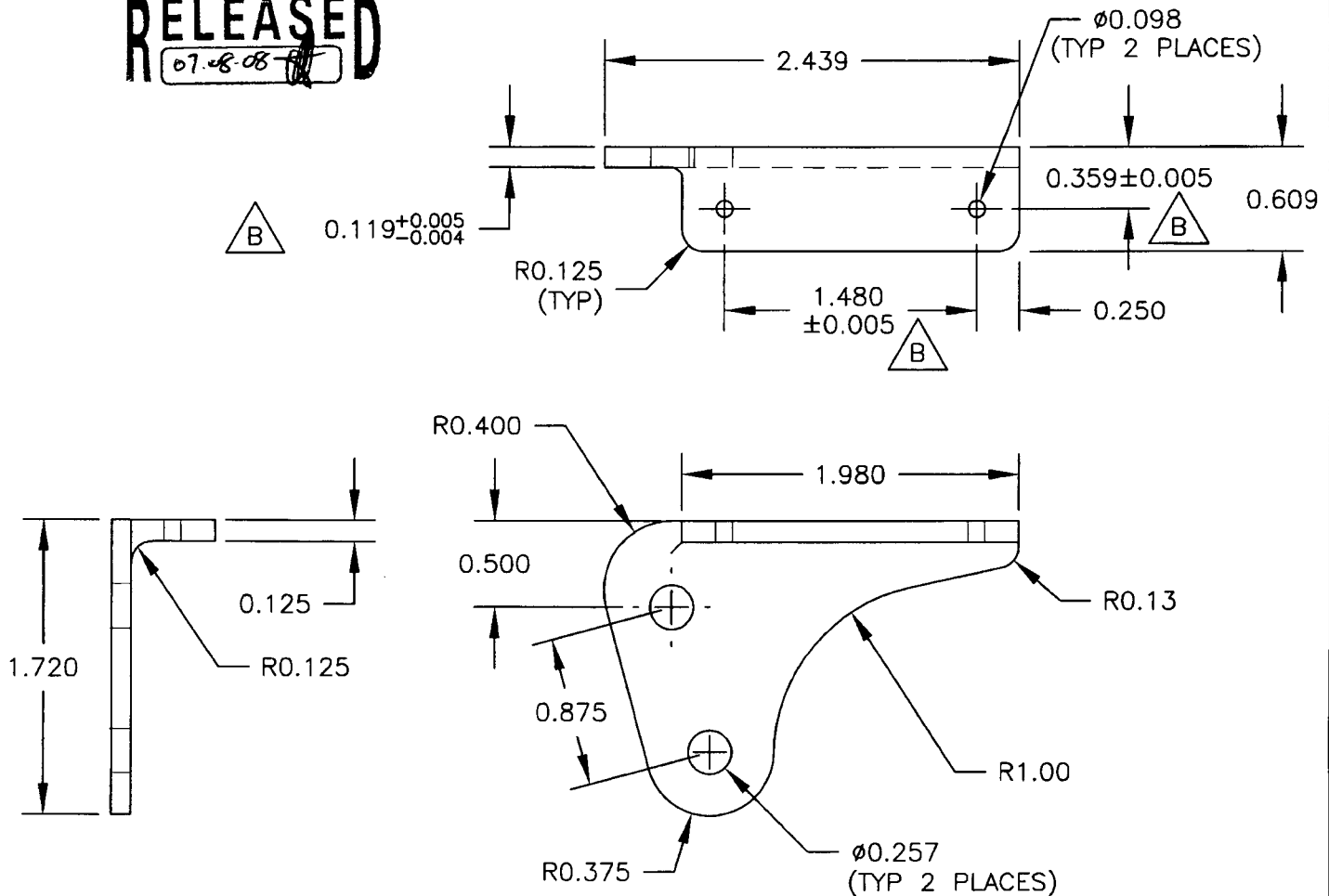
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DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED  
07-08-08



**D3278-1 SUPPORT (SHOWN)**

**D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

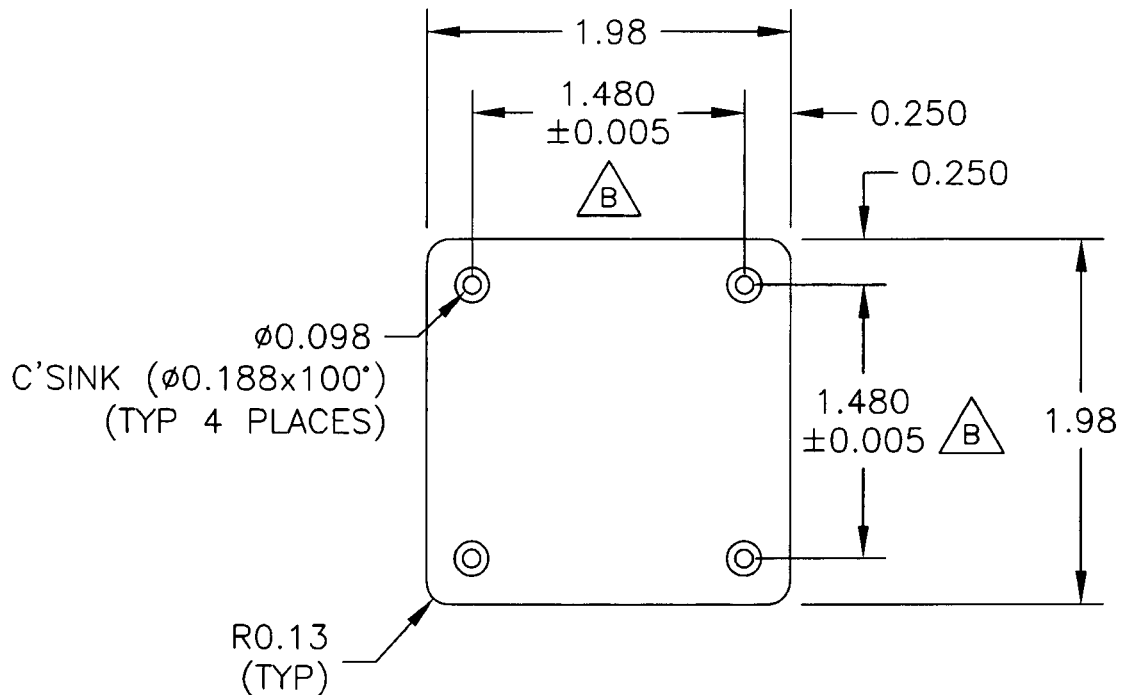
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED  
07.08.08



### D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries